

Date: Wednesday, 9/26/2007 2:09:13 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BACK FRAME ASSEMBLY		
Job Number	: 34895		Part Number	: D3017041		
Estimate Number	: 11129		Drawing Number	: D3017 REV A		
P.O. Number	:		Project Number	: N/A		
This Issue	: 9/26/2007	S.O. No. :	Drawing Revision	: A		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type	LARGE FAB ASSY	Due Date	: 10/15/2007	Qty: 1 Um: Each
Previous Run	: 33364					
Written By	:					
Checked & Approved By	:					
Comment	: Est. A 01.09.19		New issue EC			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M4130NT0750W049	4130 Tube .750 OD x.049W
<p>Comment: Qty.: 13.1250 f(s)/Unit Total : 13.1250 f(s) 4130 Tube .750 OD x.049W Cut:- AISI 4130N tube, Ø3/4" x 0.049" wall Batch: <u>M103092</u> </p>		
2.0	M4130NS049	4130 Sheet .049 wall
<p>Comment: Qty.: 0.1260 sf(s)/Unit Total : 0.1260 sf(s) 4130 Sheet .049 wall Cut:- AISI 4130N sheet, 18 gauge (0.050 thick) Batch: <u>M11612</u> </p>		
3.0	D30177	Lug
<p>Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s) Lug Pick: Qty Part Number Description Batch <u>B22411 ->1</u> 3 D3017-7 Lug <u>B38567 ->2</u> </p>		
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Cut all tubes as per Dwg D3017

2-Cut end caps as per Dwg D3017

3-Weld as per Dwg D3017 using Welding Jig Dt8598

A/R Steel Rod Batch: M1000015

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 9/26/2007 2:09:13 PM
User: Kim Johnston

Process Sheet

30m.en
18/04/2008

18/04/2008
S.052 06.07
#1 325.7 F
B 34875 F
D 3017041 F

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BACK FRAME ASSEMBLY

Job Number: 34895

Part Number: D3017041

Job Number:



Seq. #:

Machine Or Operation:

Description:

4-Drill D3017-041 Using DT8621

5-Deburr

PD 08-04-17

5.0 QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

18/04/17

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

18/04/17

7.0 POWDER COATING

POWDER COATING



M 106442

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

BK 08-04-18

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 08/04/23

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 08/04/23

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/28

Job Completion



MF 08-04-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

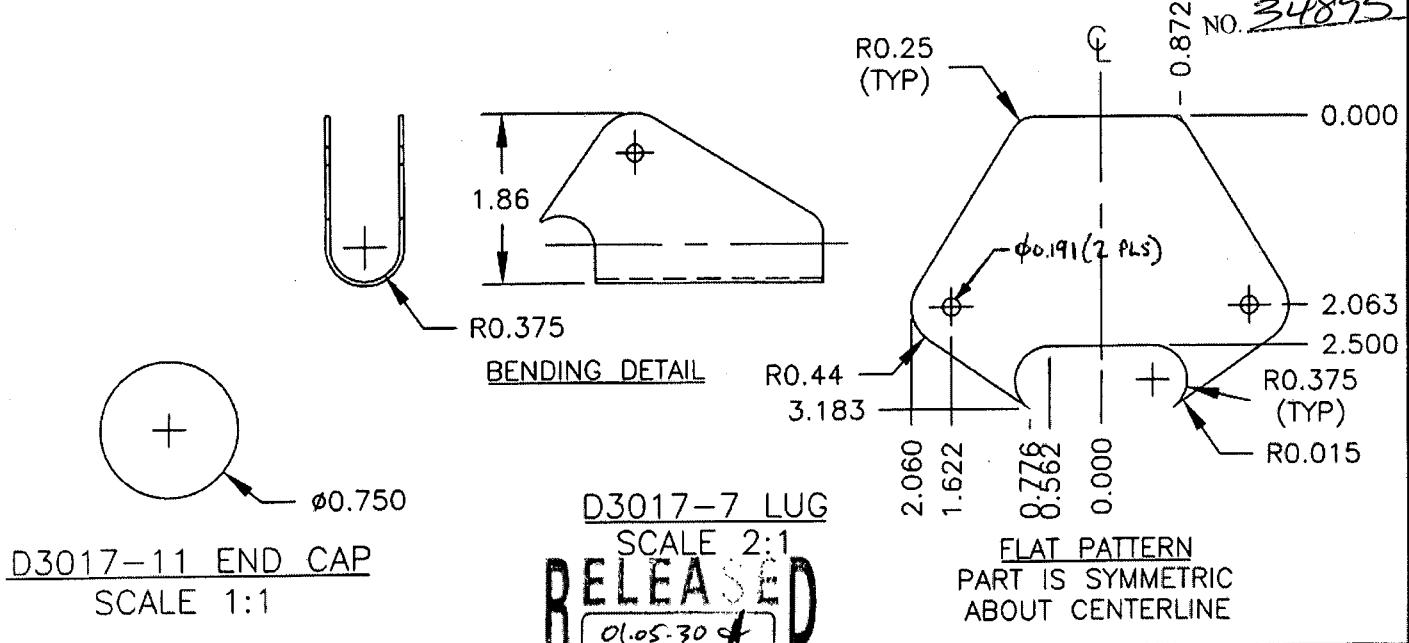
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
		D3017	SHEET 1 OF 2
DATE		TITLE	SCALE
01.05.18		BACK FRAME ASSEMBLY	1:1
A	01.05.18	NEW ISSUE	

QTY	PART No.	DESCRIPTION	MATERIAL
X	D3017-041	BACK FRAME ASSEMBLY	N/A
1	D3017-1	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
2	D3017-3	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
1	D3017-5	TUBE	AISI 4130N TUBE, Ø0.75 DIA x 0.049 WALL (M4130N-T0750W049)
3	D3017-7	LUG	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
2	D3017-11	END CAP	AISI 4130N SHEET, 18 GAUGE (M4130N-S049)

NOTES

- 1) WELD PER DART QSI 004
- 2) ON SHEET METAL PARTS, BREAK ALL UNMARKED CORNERS 0.020-0.040
- 3) FINISH: POWDER COAT GREY SANTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES.
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34895



Copyright © 2001 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

